

Date: Tuesday, 01/04/2008 8:00:27 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE
Job Number : 38263	
Estimate Number : 10910	
P.O. Number :	Part Number : D33631
This Issue : 01/04/2008 S.O. No. :	Drawing Number : D3363 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 11	Drawing Revision : C
Previous Run : 37215	Material :
Written By : <i>[Signature]</i>	Due Date : 08/04/2008 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est B 05.09.09 Remove c'sink rivet holes and add welding step KJ/JLM Est C 06.11.15 waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 2.4150 sf(s)/Unit Total : 24.1500 sf(s)

6061-T6 .063 thick aluminum Sheet

Batch: 107387 *HB 8-4-2*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



PTO

Comment: FLOW WATER JET

1-Cut as per Dwg D3363 * grain direction on A 45° L *

Dwg Rev: C

Prog Rev: C *HB 8-4-2*

2-Deburr if necessary *HB 8-4-2*

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

80/04/09

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr

Form as per Dwg D3363

80 08/04/09

PTO

(9)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE

Job Number: 38263

Part Number: D33631

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/09 (27)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Weld using DT8790 as per Dwg D3363 and QSI 004

M164855

08-04-18

FF

(9K)

08-04-17

SP

(9)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-18 (9)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/18 (28)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

FF

08-04-18

(9)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/18

Job Completion



MF 08-04-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08.04.02	2.0	Note to cut parts with the grain on a 45° L. Permanent change	[Signature]	08.04.02		[Signature] 080402	[Signature] 080402	

Part No: D3363-1 PAR #: NA Fault Category: Prod / FMS, ass. need of small NCR: Yes No DQA: D Date: 08/04/02
D212-722 QA: N/C Closed: D Date: 08/04/02

NCR: <u>38263</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/02	2.0	1 part scrap material broke Material was deburred on the deburr machine, and inside corners were not done.	[Signature] Resian	Scrap - destroy no replace - deburr remaining parts by hand on the inside radii.	SB 08/04/02	[Signature] 08.04.02	[Signature] Resian	[Signature] 080402

NOTE: Date & initial all entries

BART AEROSPACE LTD		Work Order: 38263
Description: CONSOLE		Part Number: D 3363-1
Inspection Dwg: D3363-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .469	+ .006 - .001	.471	*			
Ø .128	+ .005 - .001	.130	*			
Ø .098	+ .004 - .001	.099	*			
22.90	+/- .030	22.90	*			
14.41	+/- .030	14.41	*			
2.004	+/- .010	2.006	*			
3.058	+/- .010	3.059	*			
4.331	+/- .010	4.336	*			
5.750	+/- .010	5.752	*			
12.409	+/- .010	12.409	*			
14.097	+/- .010	14.097	*			
4.100	+/- .010	4.101	*			
4.475	+/- .010	4.475	*			
5.790	+/- .010	5.794	*			
6.390	+/- .010	6.389	*			
19.590	+/- .010	19.590	*			
10.387	+/- .010	10.387	*			
7.206	+/- .010	7.204	*			
.315	+/- .010	.317	*			
2.366	+/- .010	2.364	*			
5.415	+/- .010	5.415	*			
20.366	+/- .010	20.366	*			

Measured by: B
Date: 8-4-2

Audited by: S
Date: 8/4/02

Prototype Approval: W
Date: 8

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. C

SHEET 1 OF 3

DESIGN

Checked

DRAWN BY

DRAWING NO.

D3363

DATE

07.01.26

APPROVED

TITLE

CONSOLE ASSEMBLY

A

04.11.29

NEW ISSUE

B

05.03.28

INCREASE WIDTH BY 0.125

C

07.01.26

T'DRILL DZUS RAIL, WIDEN BASE CUTOUT

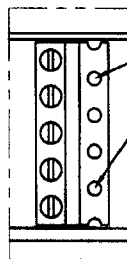
SCALE

1:5

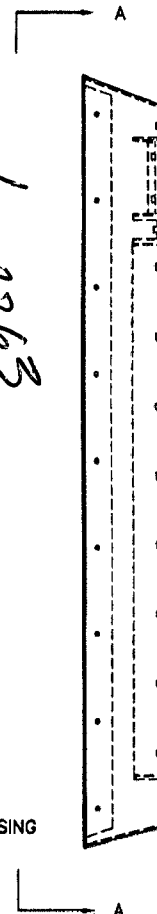
RELEASED

07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL THROUGH D3363-1 CONSOLE (TYP 4 PLACES) C'SINK (#0.225 X 100") FROM TOP SIDE OF CONSOLE



DETAIL C
(SCALE 1:2)



C'SINK THIS SIDE (REF)

u/b 38263

INSTALL D3361-1 & D3362-1 USING MS20426AD4-6 RIVETS (TYP 9 PLACES)

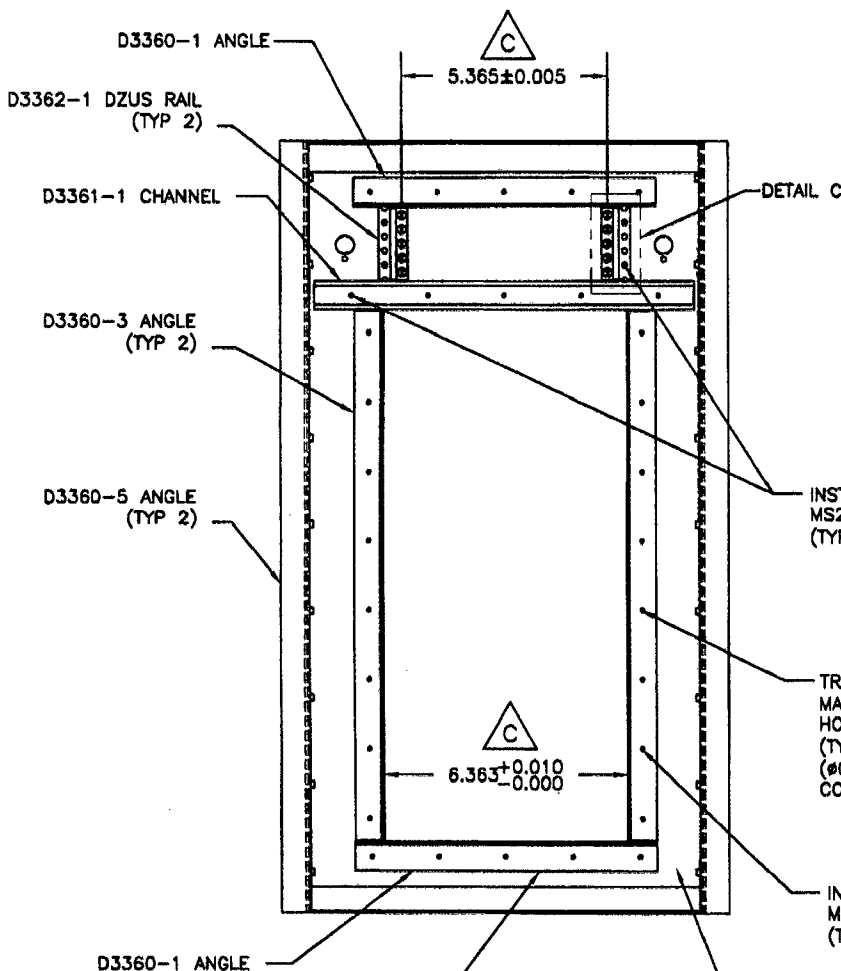
TRANSFER DRILL #30 FROM MATING PARTS THROUGH #40 HOLES IN D3363-1 CONSOLE (TYP 49 PLACES) C'SINK (#0.225 X 100") FROM CONSOLE TOP SIDE

INSTALL D3360-1/-3/-5 ANGLES USING MS20426AD4-5 RIVETS (TYP 44 PLACES)

D3363-1 CONSOLE

PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET



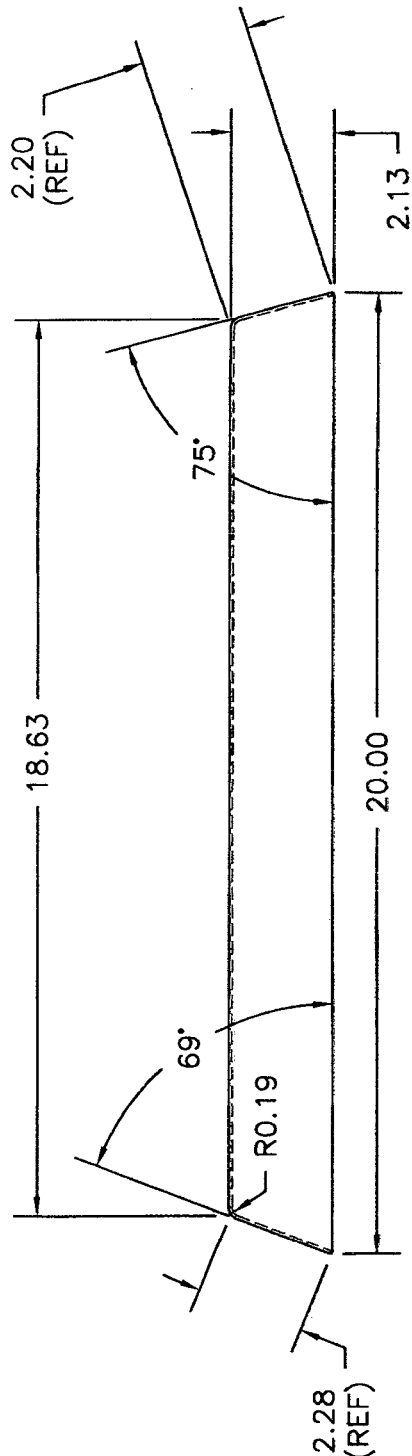
VIEW A-A FROM UNDER CONSOLE ASSEMBLY

D3363-041 CONSOLE ASSEMBLY

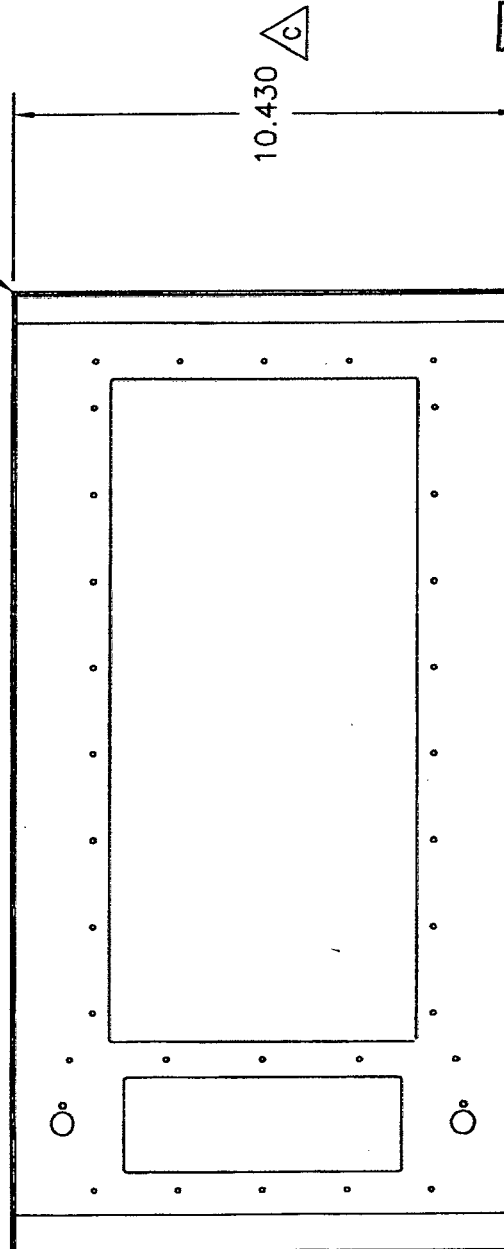
- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



GRIND OUTSIDE
WELD FLUSH
(TYP 4 PLACES)



RELEASED

07.06.04 *PH*

D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE

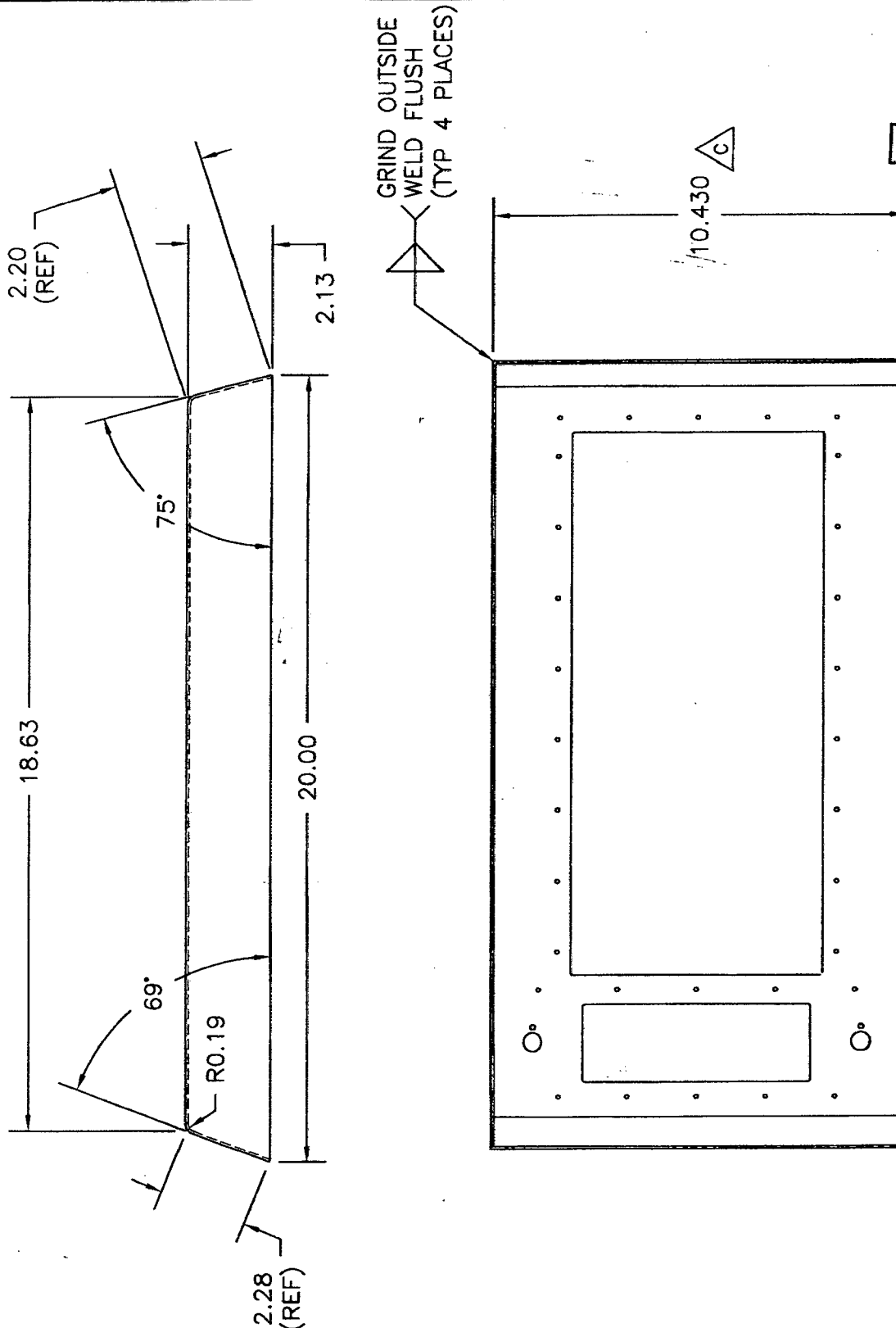
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

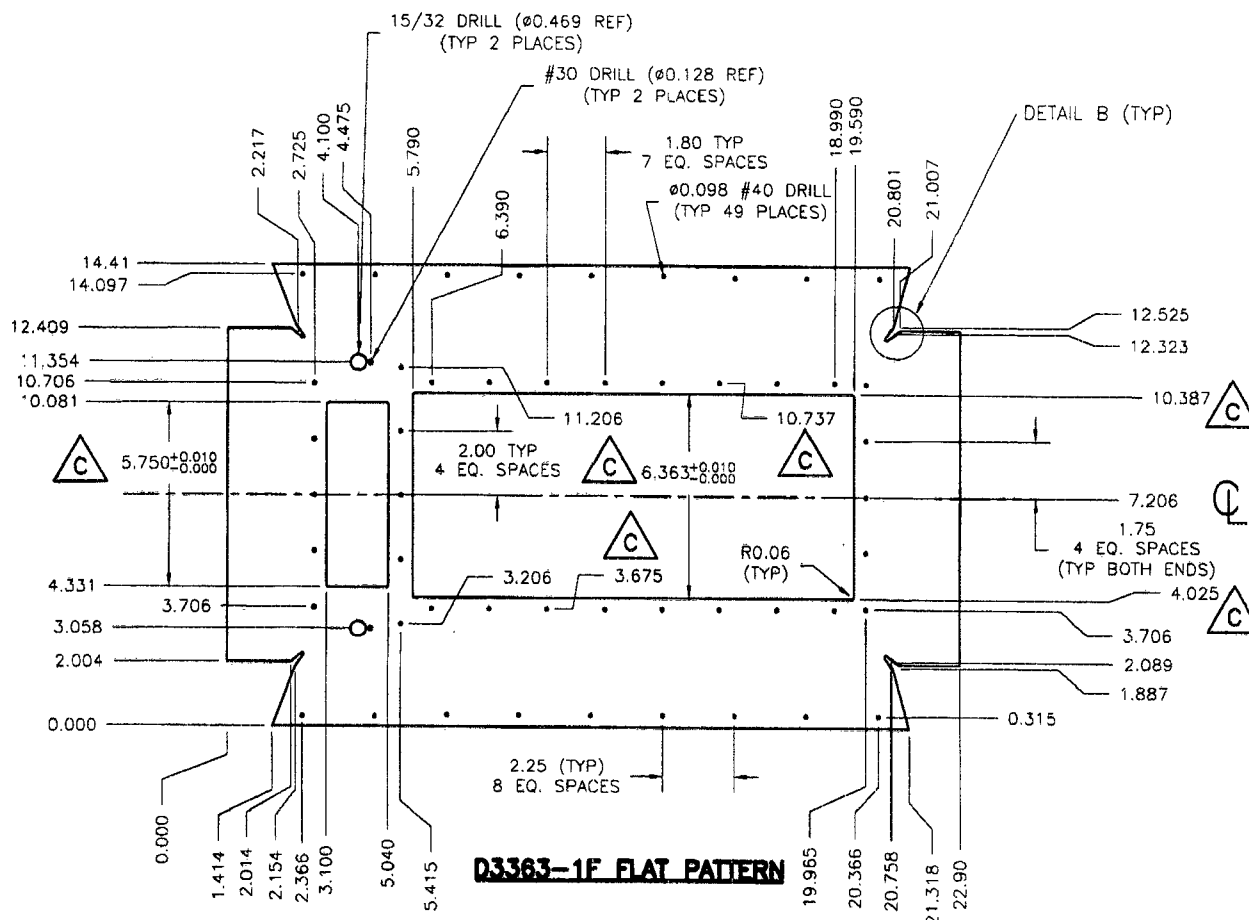
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

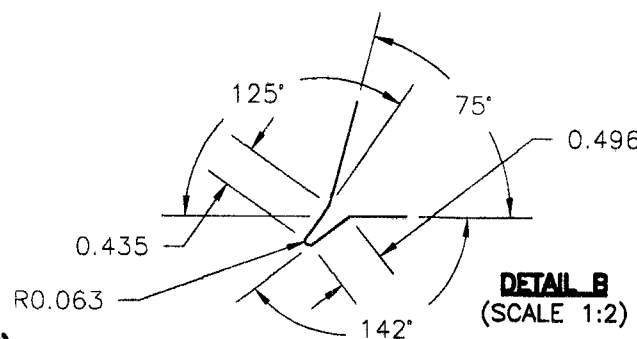


DESIGN	DRAWN BY	DART AEROSPACE LTD
GH	GH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
3	GH	D3363
DATE	TITLE	REV. C
07.01.26	CONSOLE ASSEMBLY	SHEET 3 OF 3
		SCALE 1:6

RELEASED
07.06.04



D3363-1F FLAT PATTERN



D3363-1F CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE